

Date: Wednesday, 12/11/2008 1:38:24 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 43365	
Estimate Number : 13263	
P.O. Number :	Part Number : D3758041
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3758 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 39489	Material :
Written By :	Due Date : 05/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08-11-12</u>	
Comment : Est Rev:A new issue 08-05-26 DD verified by:EC Est Rev:B 08-10-20 revA as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.0273 sf(s)/Unit Total: 0.2730 sf(s)

304/316 .032 Sheet

Batch: 109057IB 8-11-17

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3758-1

Dwg Rev: AProg Rev: AIB 8-11-17(12)

2-Deburr if necessary

IB 8-11-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-11-17**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK508/11/18 (4/2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Form as per Dwg D3758

SS 09/01/06(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:38:25 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 43365

Part Number: D3758041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/01/06 (12)

7.0	D2182B028	Rubber Cushion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

batch: B42737

CP 09/01/06 (12)

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Assemble rubber cushion as per dwg D3758

CP 09/01/06 (12)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (12)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 117

AS 09/01/07 (12)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

AS 09/01/07 (12)

Job Completion



u 09.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

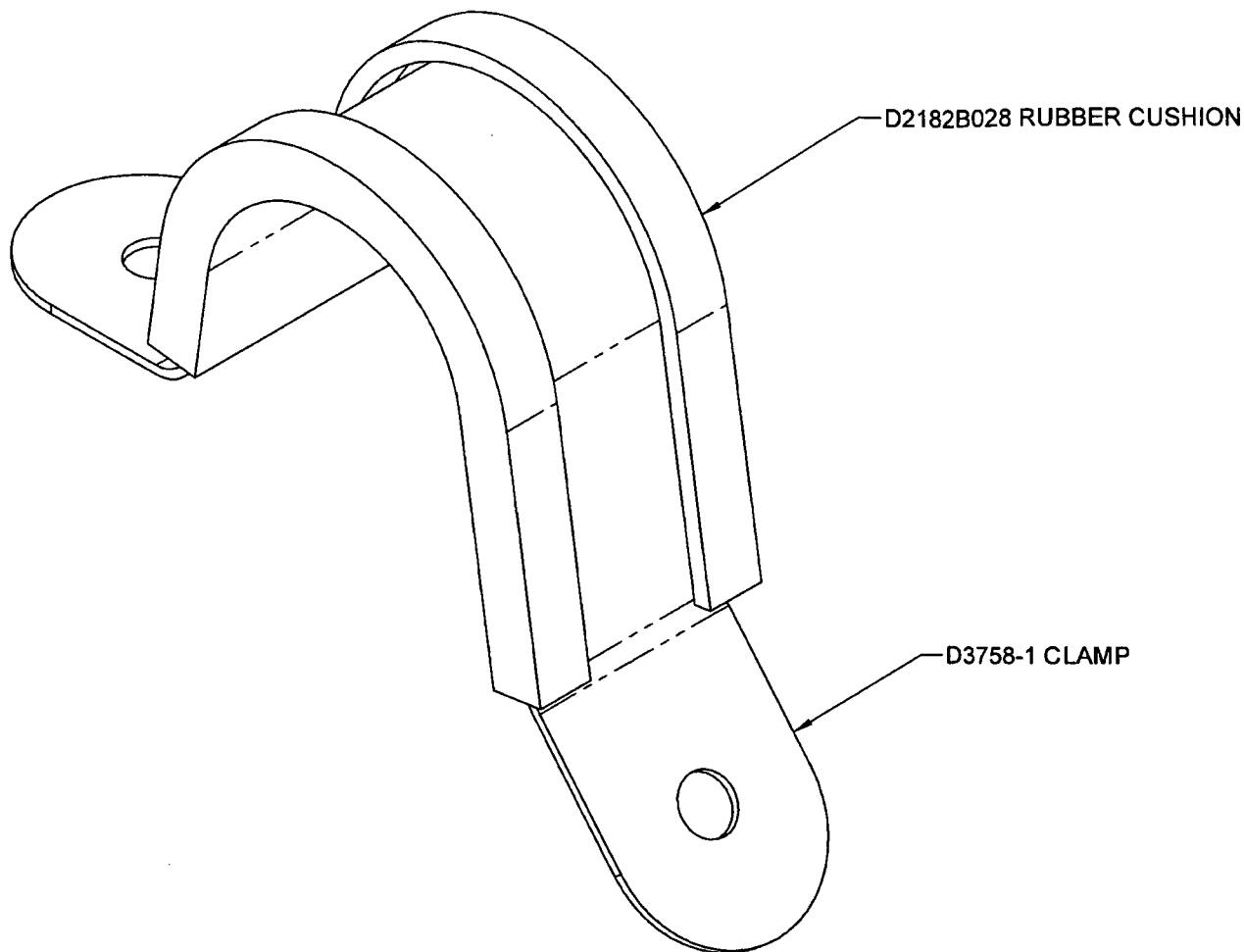
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3758-041	CLAMP
1	D3758-1	CLAMP
1	D2182B028	RUBBER CUSHION

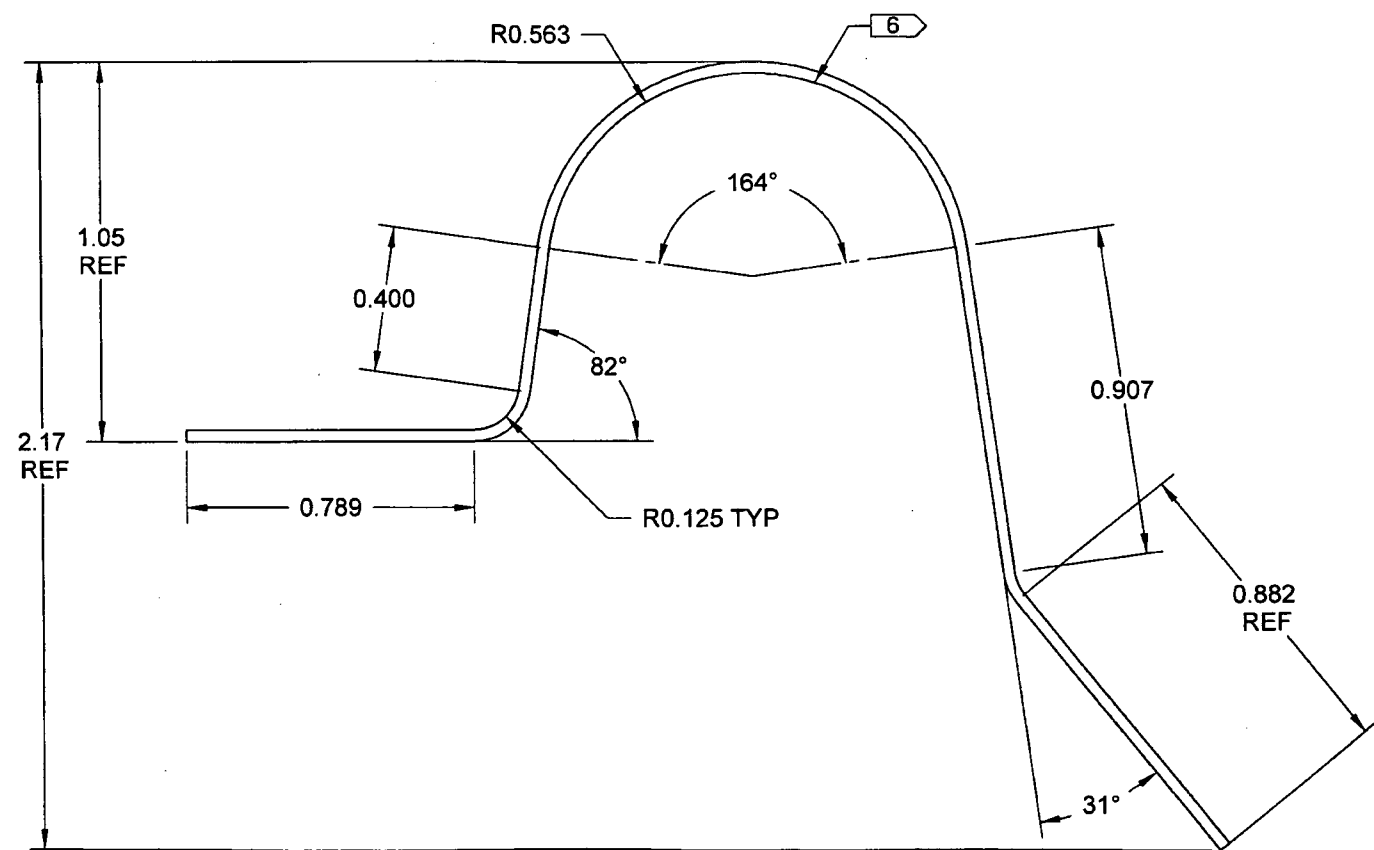
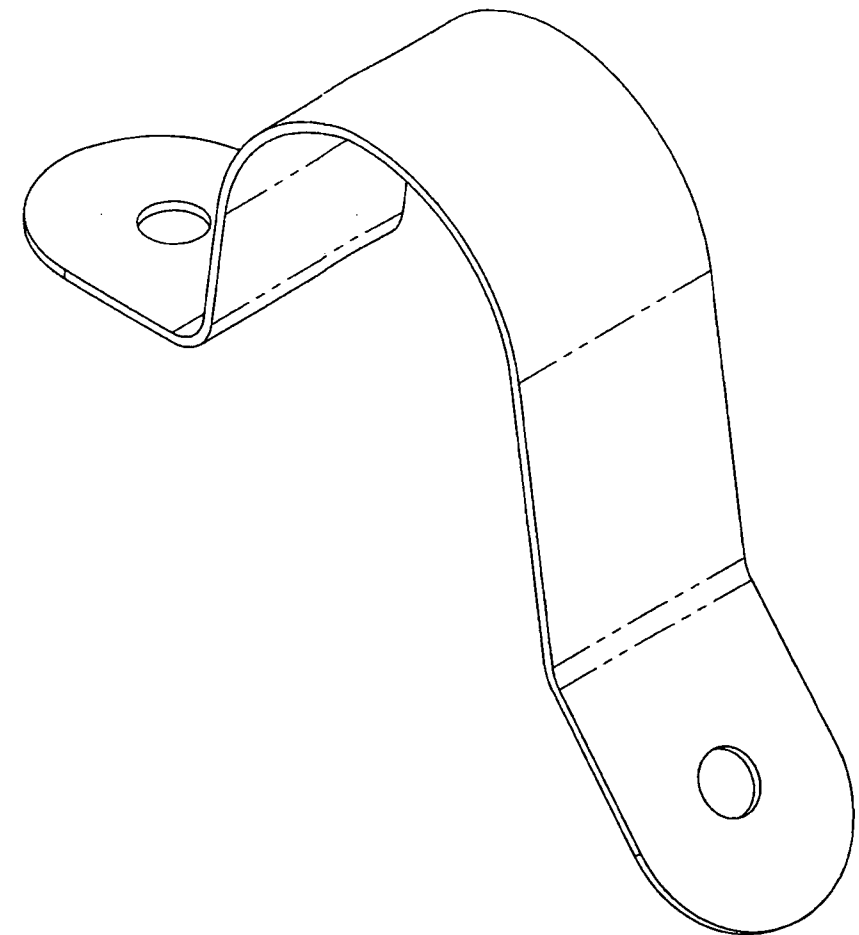
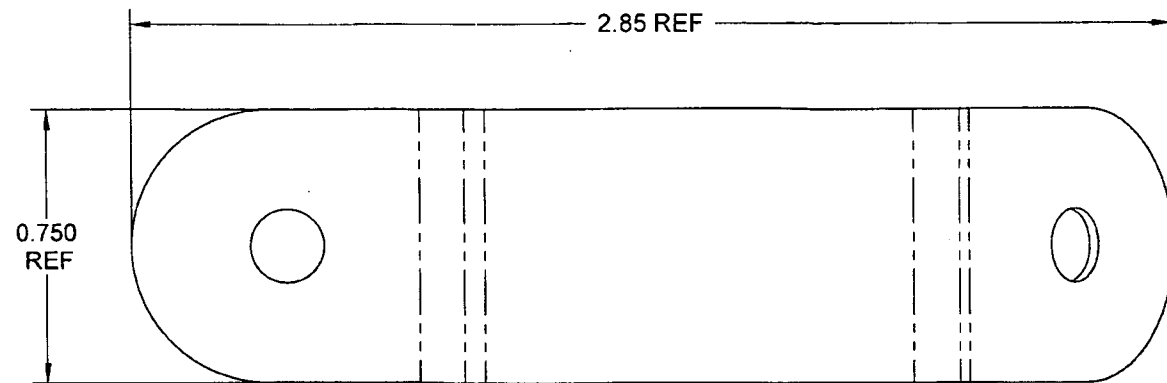


D3758-041 CLAMP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.04 lbs

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>Rlt</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MD</i>	D3758	SHEET 1 OF 3
APPROVED	<i>WJH</i>	TITLE	SCALE
DE APPR.	<i>WJH</i>	CLAMP	NTS
DATE	08.04.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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 WORK ORDER NO. 43365



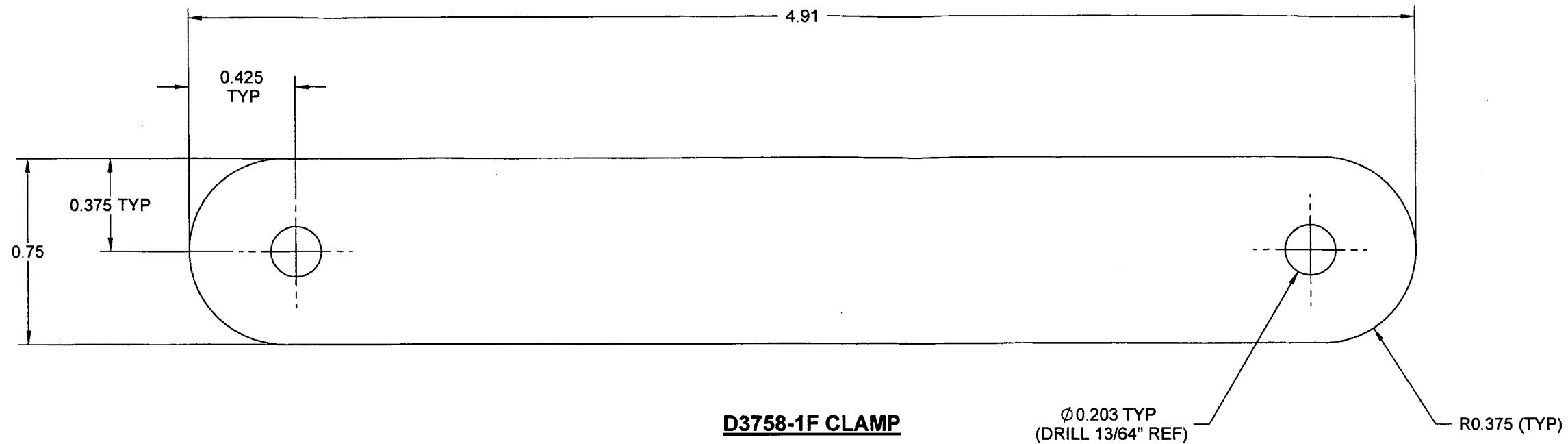
D3758-1 CLAMP

RELEASED
08.10.13-10

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WITHOUT NOTICE
WORK ORDER NO. 43305

- NOTES:**
- 1) MATERIAL: MAKE FROM D3758-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3758-1" USING FINE POINT PERMANENT MARKER
 - 7) WEIGHT: 0.03 lbs

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	AD	D3758	SHEET 2 OF 3
APPROVED	AD	TITLE	SCALE
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D3758-1F CLAMP

Ø0.203 TYP
(DRILL 13/64" REF)

R0.375 (TYP)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	Q2	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	Q2		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3758	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CLAMP	NTS
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